

Date: Wednesday, 9/19/2007 10:13:52 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : CUFF

Job Number : 34707

Estimate Number : 13023

P.O. Number : N/A

This Issue : 9/19/2007

S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A

Type : MACHINED PARTS

Previous Run : N/A

Written By : EC

Checked & Approved By : _____

Comment : est rev A new issue 07.09.19 EC verified by: JLM

Part Number : D36601

Drawing Number : D3660 UNDER REV

Project Number : N/A

Drawing Revision : U/R

Material : N/A

Due Date : 9/24/2007

Qty: 8 Um: Each

PROTOTYPE

FOR ENGINEERING USE ONLY

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6009129P

Crosstube Material



Comment: Qty.: 0.3460 Each(s)/Unit Total : 2.7678 Each(s)

D6009-129 X-TUBE MATERIAL

batch: 6265 626548CERTIFICATE OF CONFORMITY
REQUIRED07.09.20 ④

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio FA 708 & DWG D3660,

FOLIO REV: N/A

DWG REV: 07.09.20

2-Deburr as required

07.09.20 ④

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.09.20 ④

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07.09.20 ④

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.09.20 ④

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

67.09.25 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock *fe*

FOR ENGINEERING USE ONLY

Location: _____

N/A 67.09.24

8.0

QC21

FINAL INSPECTION/W/O RELEASE



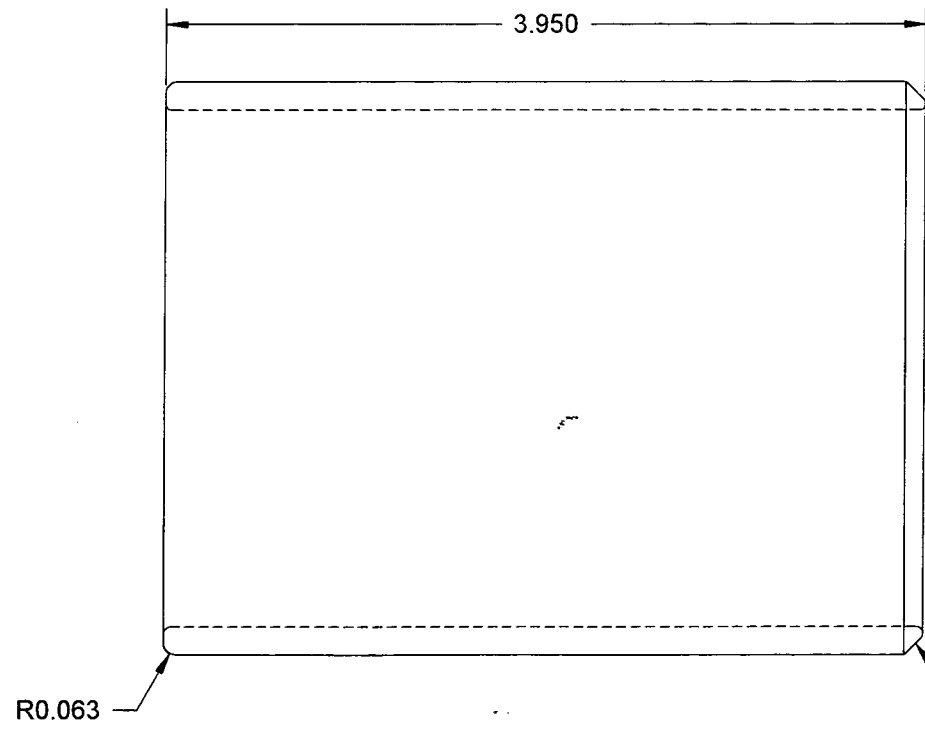
Comment: FINAL INSPECTION/W/O RELEASE

67.09.25

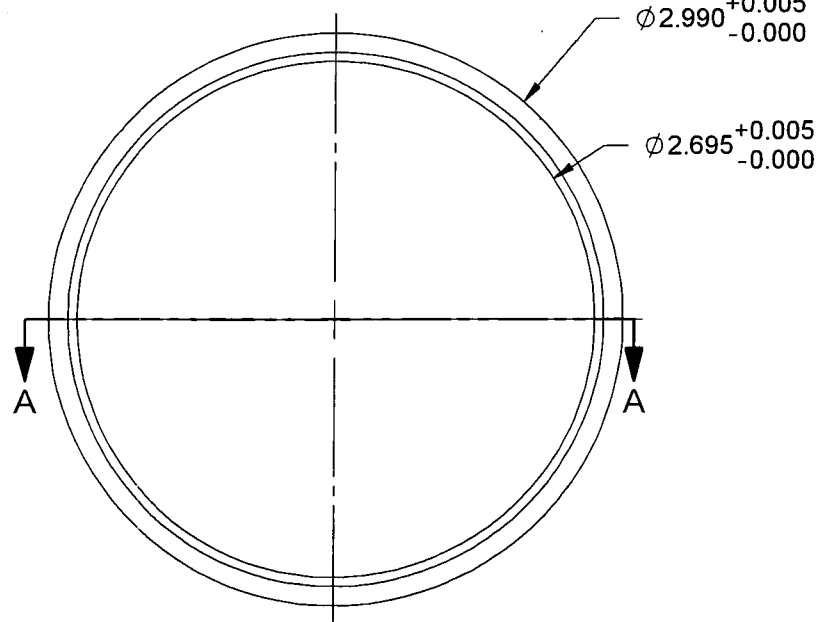
Job Completion



U 07.09.28



R0.032
(TYP INSIDE EDGES)



D3660-1 CUFF

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) WEIGHT: 0.52 lbs

A	New Issue	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3660	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CUFF	1:1
DATE	07.07.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

